



Dart Aerospace Ltd.
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Tel (613) 632-5200
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D3405-043
Job Sheet 194460



Part No: D3405-043

Job Qty: 16 pcs

Part Name: Ground Handling Lug



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/2/19

Job Tracking No:

Due Date: 5/6/19

Created By: Shannon Hadley

Type: Stock

Description:

Note: DWG REV B IPP A 05.09.01 New issue KJ/JLM IPP B 09.01.28 Rev b dwg EC verified by: DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	16 pcs		5/6/19	0.00	1.44	Waterjet - Flow		D-19/05/06
110	QC 2	16 pcs		5/6/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		D-19/05/06
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

120	QC 8	16 pcs	5/6/19	0.00 0.00	QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	MAY 07 2019
					QC 8 - 52	DAS 40 9-89
					QC 8 - 23	
130	Small Fab - Brake NC - B4B	16 pcs	5/6/19	0.09 1.16	Small Fab - Brake - 1 - B4B	DAS 30 9-89 MAY 07 2019
					Small Fab - Brake - 2 - B4B	
					Small Fab - Brake - 3 - B4B	
140	QC 5	16 pcs	5/6/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	MAY 07 2019
150	Large Fab - Welded Assy-2-B4B	16 pcs	5/6/19	0.00 4.75	Large Fab - 1 - B4B	DAS 40 9-89
					Large Fab - 10 - B4B	
					Large Fab - 2 - B4B	
					Large Fab - 3 - B4B	
					Large Fab - 4 - B4B	
					Large Fab - 5 - B4B	
					Large Fab - 6 - B4B	
					Large Fab - 7 - B4B	
					Large Fab - 8 - B4B	
					Large Fab - 9 - B4B	

160 QC 9	16 pcs	5/6/19	0.00 0.00	QC 9 - 10	
				QC 9 - 18	
				QC 9 - 24	
				QC 9 - 43	
				QC 9 - 50	
				QC 9 - 9	
170 QC 5	16 pcs	5/6/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
180 Powdercoat - 2 White Gl(S)- B4B	16 pcs	5/6/19	0.00 0.44	Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	
				Powdercoat - 4 - B4B	
190 QC 3	16 pcs	5/6/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
200 Packaging 3-1 - Stock - B4B	16 pcs	5/6/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	

DAS
24
9-89

MAY 09 2019

DAS
24
9-89

MAY 09 2019

180 Powdercoat - 2 White Gl(S)-
B4B *M151749.*
START: 2:50 OUT: 400° FINISH: 2:20

BK19-5-9

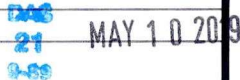
DAS
40
9-89

MAY 09 2019

DAS
28
9-89

				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
210	QC 21 - SA	16 pcs	5/6/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53

Part Op **100** - 1-Cut as per Dwg D3405 Dwg Rev: B Prog Rev: B 2-Deburr if necessary
 Descriptions: **110** - (QC2- Inspect parts off machine FAI/FAIB)
120 - (QC8- Inspect parts - second check)
130 - 1-Deburr 2-Form using DT8204 as per Dwg D3405 3- use DT9681 to check if correct forming
140 - (QC5- Inspect part completeness to step on W/O)
150 - Weld as per Dwg D3405 use DT8484 Identify as D3405-043
160 - (QC9- Inspect visual per QSI004- Fusion Welds)
170 - (QC5- Inspect part completeness to step on W/O)
180 - (White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel) START TIME: _____ OVEN TEMPERATURE: _____
 FINISH TIME: _____
190 - (QC3- Inspect Part Finish)
200 - (Identify as per dwg & Stock Location: _____)
210 - (QC21- Final Inspection - Work Order Release)



Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M304S11GA	304/316 0.125 Sheet	2.4640 sf (.154 ea)	100-Waterjet - Flow - 1	5159397
D3404-1	Ground Handling Wheel Lug	16 pcs (1 ea)	150-Large Fab - Welded Assy-2- B4B	5169664

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S11GA	2	97	0
150-Large Fab - Welded Assy-2- B4B	D3404-1	16	70	0

Part Specifications	
Specifications could not be found.	



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D3405-043
Job Sheet 190922



Part No: D3405-043

Job Qty: 16 ea

Part Name: Ground Handling Lug



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/20/19

Job Tracking No:

Due Date: 4/15/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV B IPP A 05.09.01 New issue KJ/JLM IPP B 09.01.28 Rev b dwg EC verified by: DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	16 pcs		4/15/19	0.00	1.44	Waterjet - Flow		
110	QC	16 pcs		4/15/19	0.00	0.00	QC2 Waterjet-2		
120	QC	16 pcs		4/15/19	0.00	0.00	QC8-2		
130	Brake NC	16 pcs		4/15/19	0.09	1.16	Brake NC 1		
140	QC	16 pcs		4/15/19	0.00	0.00	QC5		
150	Large Fab	16 pcs		4/15/19	0.00	4.75	Large Fab 1		
160	QC	16 pcs		4/15/19	0.00	0.00	QC9		
170	QC	16 pcs		4/15/19	0.00	0.00	QC5		
180	Powdercoat	16 pcs		4/15/19	0.00	0.44	Powdercoat2		
190	QC	16 pcs		4/15/19	0.00	0.00	QC3		
200	Packaging	16 pcs		4/15/19	0.00	0.00	Packaging3-1		
210	QC21-SA	16 Ea		4/15/19	0.00	0.00	QC21		

Part Op 100 - 1-Cut as per Dwg D3405 Dwg Rev: _____ Prog Rev: _____ 2-Deburr if necessary
 Descriptions: 130 - 1-Deburr 2-Form using DT8204 as per Dwg D3405 3- use DT9681 to check if correct forming
 150 - Weld as per Dwg D3405 use DT8484 Identify as D3405-043
 180 - START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S11GA	304/316 0.125 Sheet	2.4640 sf (.154 ea)	100-Waterjet - Flow - 1	
D3404-1	Ground Handling Wheel Lug	16 pcs (1 ea)	150-Large Fab	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S11GA	2	31	0
150-Large Fab	D3404-1	16	30	0

Part Specifications

Specifications could not be found.

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QS1042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

DART
AEROSPACE

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Container No: S178509



Part: D3405-043

Job No: 194460

Serial No/Batch: S178509

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 05/07/19